

Work Order ID 128258

Tuesday, January 13, 2015 1:38:48 PM

128258

Page 1

Item ID: D4855-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Antenna Bracket (Replaces P/N G13013-3)

Start Date: 1/13/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MJS Date: 15-01-14

Tooling:

Date:

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4855	A								
100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00				12	Ø		DAS 44 9-89 15/01/19
Jeaspa Bandsaw	CUT BLANK AT 3.000"								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00				12	Ø		DAS 44 9-89 15/01/19
HAAS CNC vertical machine #1	1-Machine per folio FB200 DWG REV: <u>A</u> FOLIO REV: <u>A</u>								
	2- deburr and break all sharp edges								DAS 20 9-89 15-01-20

Tuesday, January 13, 2015 1:38:48 PM

128258

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Antenna Bracket (Replaces P/N G13013-3)

Start Date: 1/13/2015 **Start Qty:** 12.00 ***12***

Cust Item ID:

Required Date: 1/20/2015 **Req'd Qty:** 12.00 ***12***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									DAS
QC									44
Quality Control	Memo	0.00				12	Ø		9-89 15/01/19
									DAS
									20
									9-89 15-01-20
130	QC8- Inspect parts - second check	0.00							
130									DAS
QC									40
Quality Control	Memo	0.00				12	Ø		9-89
									15/01/21
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish									
Hand Finishing	Memo	0.00				12x	Ø	90	15/01/25

Work Order ID 128258***128258***

Page 3

Item ID: D4855-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Antenna Bracket (Replaces P/N G13013-3)

Stop ***NS2***Start Date: 1/13/2015 Start Qty: 12.00 ***12***

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 12.00 ***12***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:25 OVEN TEMPERATURE: 320° FINISH TIME: 9:55								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

FEB 02 2015

Work Order ID 128258

Tuesday, January 13, 2015 1:38:48 PM

128258

Page 4

Item ID: D4855-1

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Antenna Bracket (Replaces P/N G13013-3)

Start Date: 1/13/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>4526</u>	0.00							
180									
Packaging	Memo	0.00				<u>12</u>	<u>MLJ</u>	<u>15-02-04</u>	
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00				<u>MLJ</u>	<u>15-02-04</u>		
Quality Control									

ME
15-2-4

Picklist Print

Tuesday, January 13, 2015 1:38:51 PM

Page 1

Work Order ID: 128258

128258

Parent Item: D4855-1

D4855-1

Parent Item Name: Antenna Bracket (Replaces P/N G13013-3)

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV: A NEW ISSUE JFS 13/06/26 VERIFY BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B4.500X4.500

Purchased

No

100

f

4.2000

0.25

4

M6061T6B4 500X4 500

6061-T6 Aluminum Bar 4.500" X 4.500"

**DAS
44
9-89**

15/01/19

Location

Loc Qty

Loc Code

MAT007

4.2

m127713

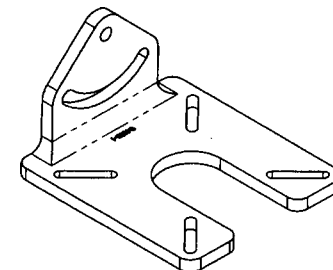
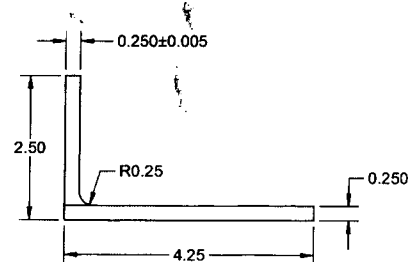
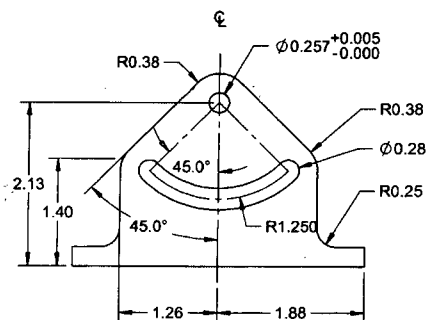
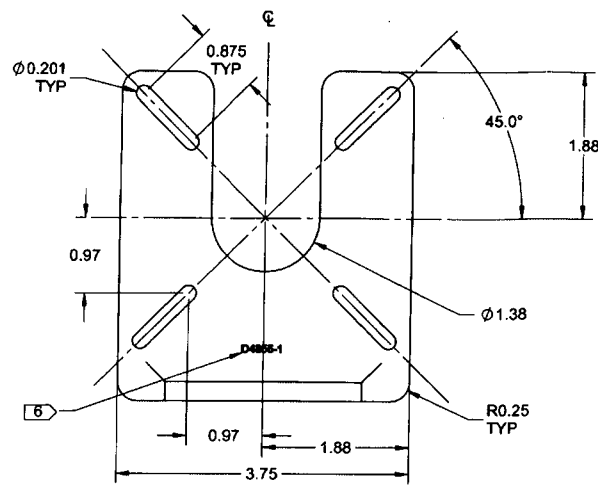
2.1

* m128573

2.1

.25'
2.83'

Could not pull mat'l !



ORIGINAL COPY
 D485-1
 1501-14

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
 QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 REF DART SPEC M6061T6B
 OR
 2024-T3/T3510/T3511 ALUMINUM ANGLE
 PER AMS-QQ-A-200/3 OR AMS 4152, 4164 & 4165
 REF DART SPEC M2024T3A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS SHOWN PER QSI 044 6.3 TO A DEPTH
 OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP
 RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.14 lbs
- 8) REPACES GENEVA P/N G13013-3

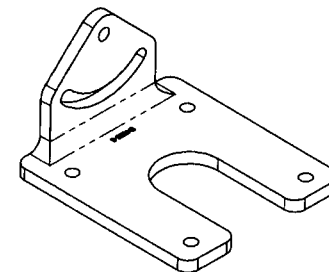
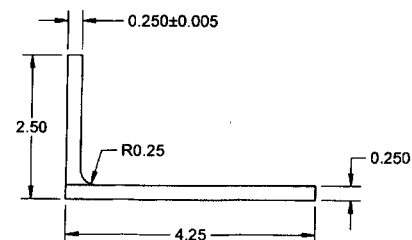
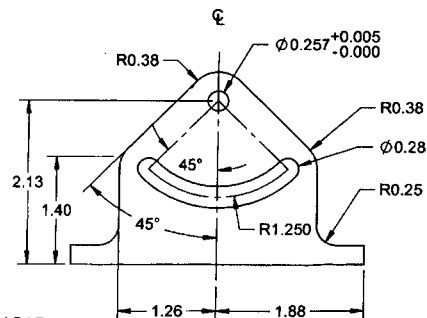
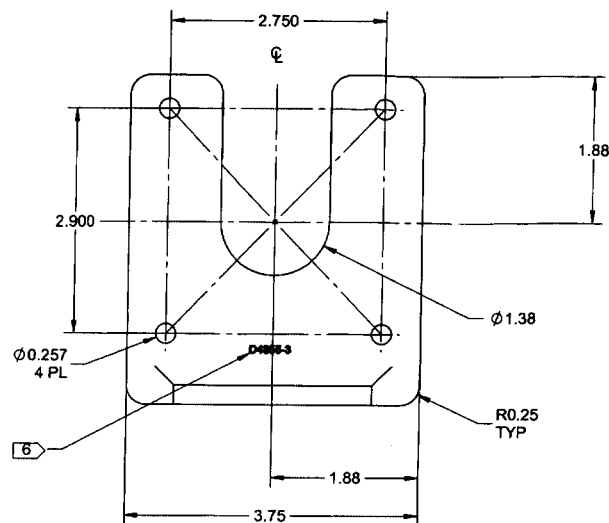
D485-1 ANTENNA BRACKET

RELEASED
 2013-07-16

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	13.05.15			

DART AEROSPACE LTD		REV. A
HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 2
DRAWING NO.	D4855	SCALE
TITLE	ANTENNA BRACKET	NTS

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NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
OR
2024-T3/T3510/T3511 ALUMINUM ANGLE
PER AMS-QQ-A-200/3 OR AMS 4152, 4164 & 4165
REF DART SPEC M2024T3A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS SHOWN PER QSI 044 6.3 TO A DEPTH
OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP
RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.15 lbs

D4855-3 ANTENNA BRACKET

RELEASED
2013-07-16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4855	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ANTENNA BRACKET	NTS
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